

Date: Wednesday, 2/7/2007 2:36:27 PM
 User: Jean-Luc Menard

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	GUIDE ASSEMBLY
Job Number	30675	Part Number	D3572041
Estimate Number	12709	Drawing Number	D3572 UNDER REVIEW
P.O. Number		Project Number	AC0002
This Issue	2/7/2007	Drawing Revision	U/R
Prsht Rev.	NC	Material	
First Issue	/ /	Due Date	2/14/2007
Previous Run		Qty:	2
Written By	<u>JLM</u> 07-02-07	Um:	Each
Checked & Approved By			
Comment	Est Rev.A New Issue 07-02-07 JLM		

Additional Product

Job Number:	
-------------	---

Seq. #:	Machine Or Operation:	Description:
1.0	D35723	GUIDE
		

Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

GUIDE

Batch: B30670

PD 07-02-08 ②

2.0	D35727	CAP
		

Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

CAP

Batch: B30672

PD 07-02-08 ②

3.0	D35725	BRACKET
		

Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

BRACKET

Batch: B30671

PD 07-02-08 ②

4.0	M6061-T6 TS0750W062	6061-T6 SQ Tube.75x.062W
		

Comment: Qty.: 2.3405 f(s)/Unit Total : 4.6809 f(s)

6061-T6 SQ Tube.75x.062W

Batch: M103069

7/7/07-02-07

5.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
		

Comment: LARGE FABRICATION RESOURCE 1

1-Weld as per Dwg D3572

A/R AL ROD

Batch: P110023

2-Blend end Caps.

PD 07-02-08 ②

Date: Wednesday, 2/7/2007 2:36:28 PM

User: Jean-Luc Menard

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GUIDE ASSEMBLY

Job Number: 30675

Part Number: D3572041

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP

*07/02/08 (2)*

Comment: INSPECT WORK TO CURRENT STEP

7.0 QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/02/08 (2)

8.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

07/02/08 (2)

9.0 POWDER COATING

POWDER COATING

*M101601**(2x)*

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M.F./a.m 07/02/08

10.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07/02/08 (2)

11.0 PACKAGING 1

PACKAGING RESOURCE #1

**ENGINEERING
APPROVAL**

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *14A1 07/02/08 (2)*

12.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

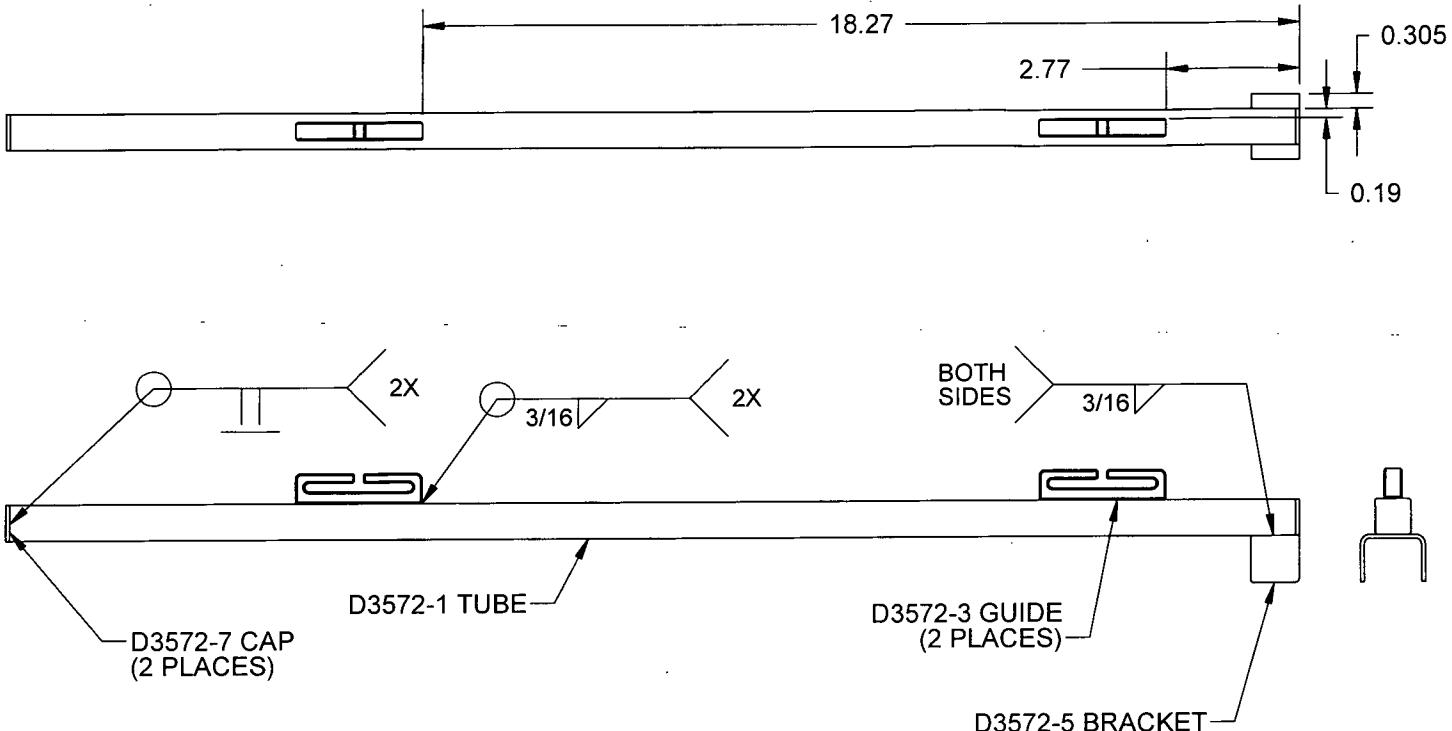
Job Completion

*C 07/02/08*

**PRELIMINARY ISSUE
UNDER REVIEW**

07.02.07 LE

DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3572	REV. A SHEET 1 OF 3
DATE 07.02.02		TITLE GUIDE ASSEMBLY	SCALE 1:4
REV A	DATE 07.02.02	DESCRIPTION NEW ISSUE	



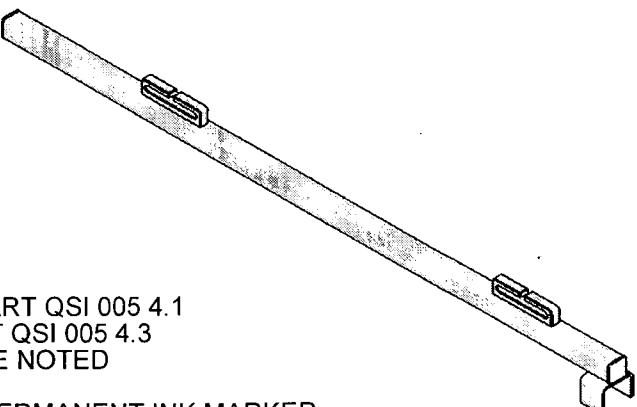
D3572-041 GUIDE ASSEMBLY

D3572-041 PARTS LIST:

QTY	P/N	DESCRIPTION
X	D3572-041	GUIDE
1	D3572-1	TUBE
2	D3572-3	GUIDE
1	D3572-5	BRACKET
2	D3572-7	CAP

D3572-041 NOTES:

- 1) FINISH: CHEMICAL CONVERSION COAT ASSEMBLY PER DART QSI 005 4.1
POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) WELD PER DART QSI 004
- 4) IDENTIFY WITH DART P/N "D3572-041" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

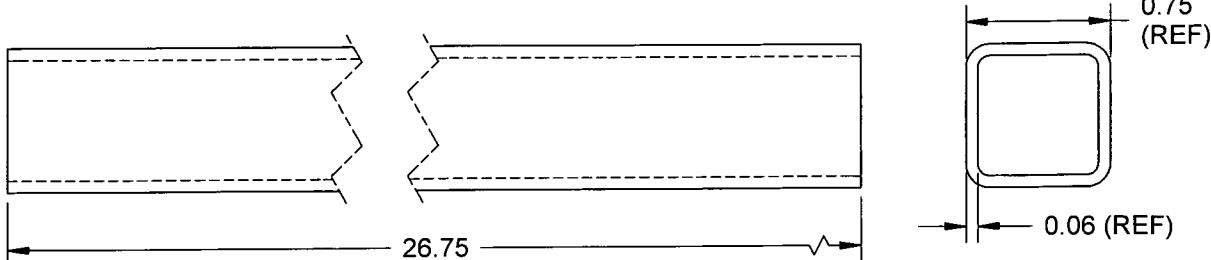


PRELIMINARY ISSUE

UNDER REVIEW

07-02-07 45

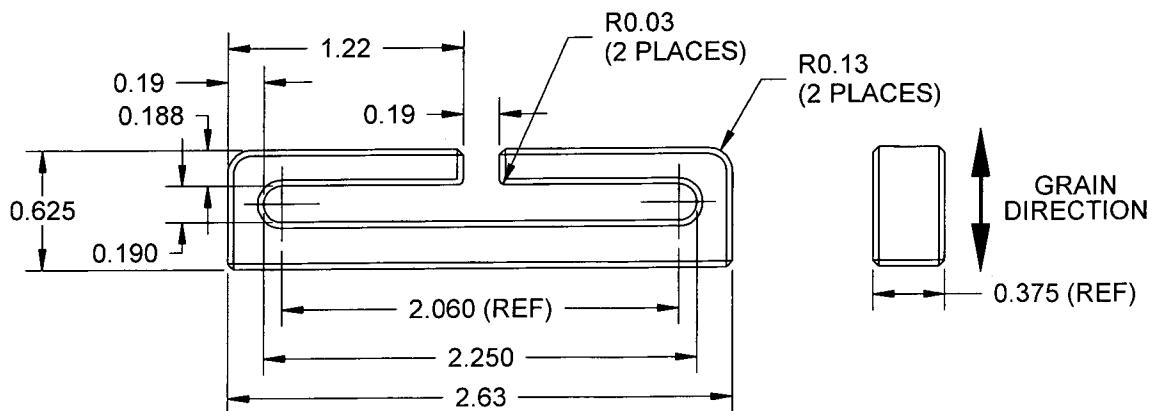
DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3572	REV. A SHEET 2 OF 3
DATE 07.02.02		TITLE GUIDE ASSEMBLY	SCALE 1:1



D3572-1 TUBE

D3572-1 NOTES:

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM SQUARE TUBE 0.750 X 0.062
PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116 OR AMS 4160
(REF DART SPEC M6061T6TS0.750W.062)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX



D3572-3 GUIDE

D3572-3 NOTES:

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) BAR
PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116 OR AMS 4160
(REF DART SPEC M6061T6B)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX